

Date: Monday, 10/11/2008 3:35:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 43294
 Estimate Number : 11403
 P.O. Number :
 This Issue : 10/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 41797
 Written By :
 Checked & Approved By : JLD 08.11.11
 Comment : Est. C 05.10.14 Added step 14 KJ/EC
 Est Rev:D Revised Steps 06-11-20 JLM

Drawing Name : DOOR ASSEMBLY
 Part Number : D3296041
 Drawing Number : D3296 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 21/11/2008

Qty: split 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Door Panel

Pick:

Qty Part Number Description Batch

1	D3296-1	Door Panel	B39744
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B42630

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Door Panel

Pick:

Qty Part Number Description Batch

1	D3296-3 Door Panel	B39745
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42031

3.0	D31617	Hinge 14.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Hinge 14"

Batch: B41806

4.0	D31619	Hinge 17.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Hinge 17"

Batch: 41807

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43294

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total : 250.0000 Each(s)

Rivet, Universal Head

Batch: M109545

SP

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Fabricate & assemble as per Dwg D3296.

FF 08/11/25

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

500/11/25 (10)

8.0

POWDER COATING

POWDER COATING



M105642



(10X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 10:00

OVEN TEMPERATURE: 320 OF

FINISH TIME: 10:30

M-1 08/11/26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/11/26 (10)

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Decal - No Step

Pick:

Qty	Part Number	Description	Batch
1	D2137	Decal	B43312

SP

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Handle

Pick:

Qty	Part Number	Description	Batch
1	D2419	Handle	B42100

8/11/19

(10X)

SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43294

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2462

Seal



Comment: Qty.: 0.3333 f(s)/Unit Total : 3.3330 f(s)

Qty Part Number Description Batch

1 D2462 Seal B37747

CUT ONE PIECE 4.00" LONG

SP

13.0

D2462

Seal



Comment: Qty.: 0.4420 f(s)/Unit Total : 4.4200 f(s)

Qty Part Number Description Batch

1 D2462 Seal B37747

CUT ONE PIECE 5.30" LONG

SP

14.0

D2462

Seal



Comment: Qty.: 2.0420 f(s)/Unit Total : 20.4200 f(s)

Qty Part Number Description Batch

1 D2462 Seal B37747

CUT ONE PIECE 24.50" LONG

SP

15.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal B39012

SP

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer M6085

8/1/19

SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43294

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Rivet, Universal Head

Pick:

Qty Part Number

Description Batch

1 MS20470AD4-6 Rivet

M108377

8/11/19

XOX

SP

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3296

FF 08/11/26 (1x)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/11/26 (40)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

28/11/26 (1)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/27

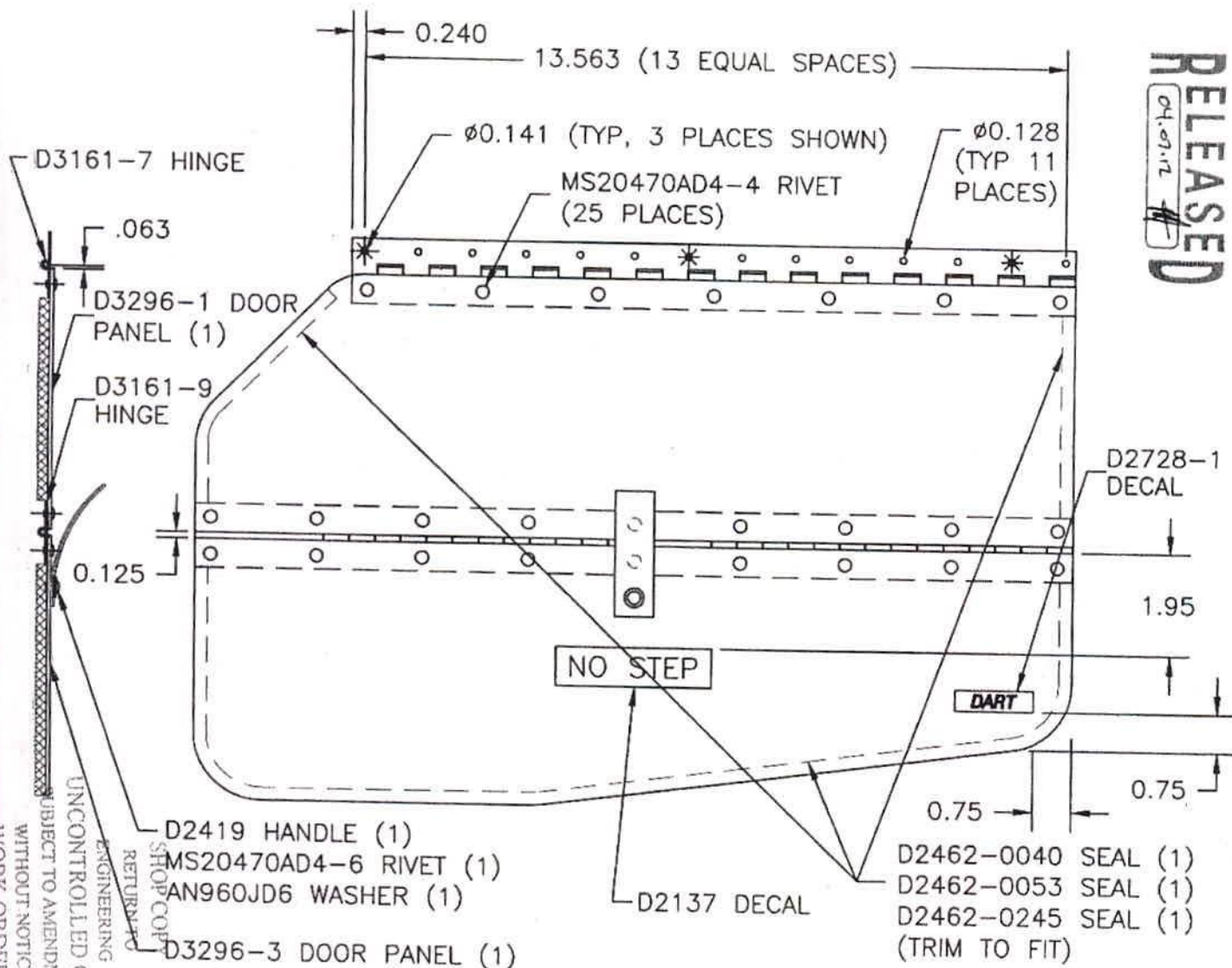
Job Completion



MF 08-11-26

DART**RELEASED**
04.07.12

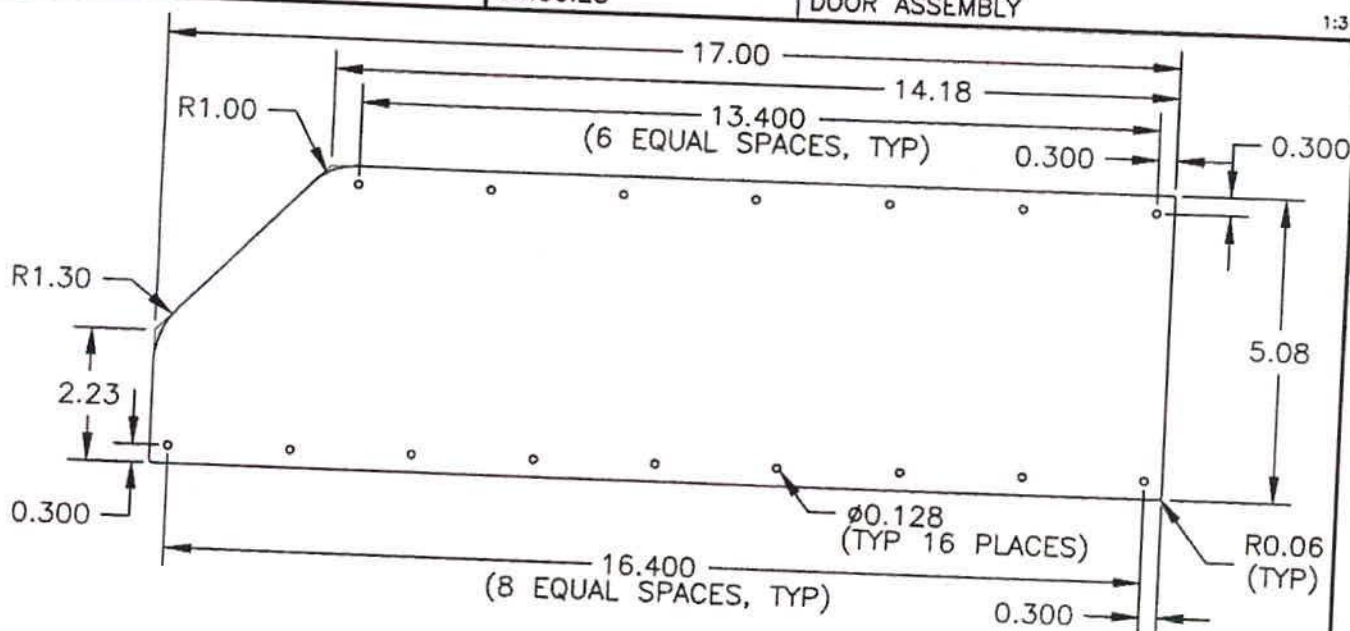
DESIGN	DRAWN BY	DART AEROSPACE LTD
C.P.	C.P.	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
[Signature]	[Signature]	D3296
DATE	TITLE	REV. A
04.06.28	DOOR ASSEMBLY	1 OF 2
A	04.06.28	SCALE
	NEW ISSUE	1:3

**D3296-041 DOOR ASSEMBLY**

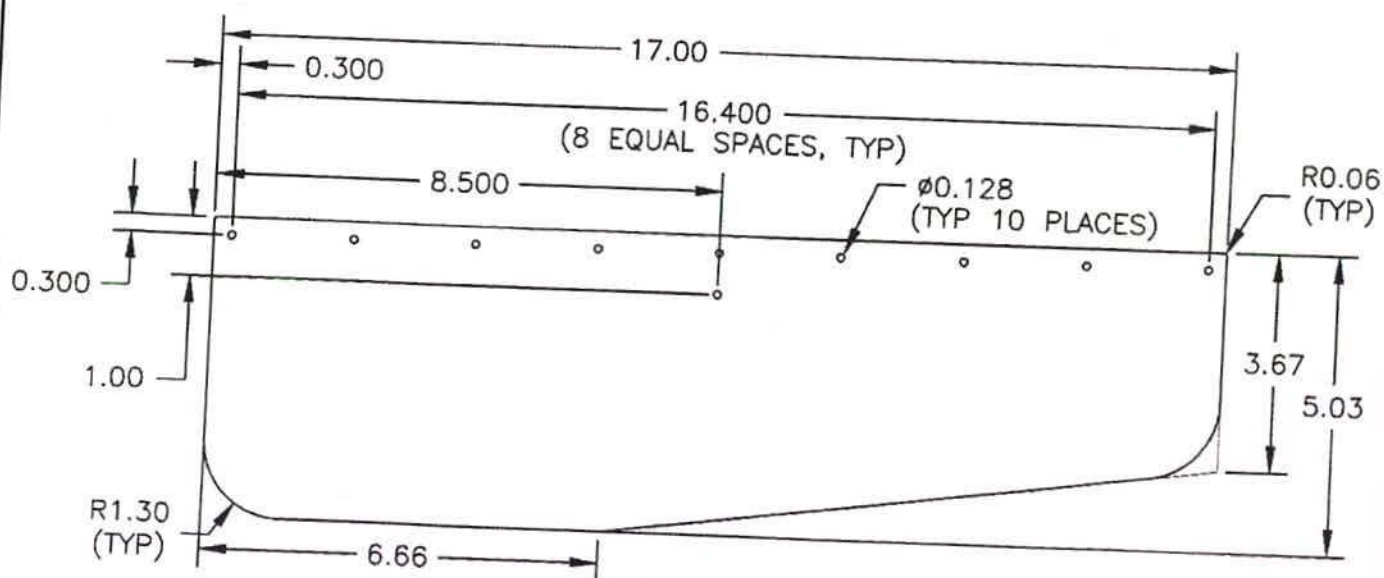
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43294